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D3319-3

Job Sheet 192190



Part No: D3319-3

Job Qty: 12 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 4/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER
DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	4/5/19	4/5/19	0.00	2.80	Waterjet - Flow		OK 19/03/27
110	QC	12 pcs	4/5/19	4/5/19	0.00	0.00	QC2 Waterjet-2		OK 19/03/27
120	QC	12 pcs	4/5/19	4/5/19	0.00	0.00	QC8-2		MAD 29 2019 DAS 40
140	Brake NC	12 pcs	4/5/19	4/5/19	0.12	0.84	Brake NC 1		9-89
150	QC	12 pcs	4/5/19	4/5/19	0.00	0.00	QC5		EL
160	Automated Welding - B4B	12 pcs	4/5/19	4/5/19	0.00	3.82	Automated Welding - 1 - B4B		1BC
170	QC	12 pcs	4/5/19	4/5/19	0.00	0.00	QC10		EL
180	QC	12 pcs	4/5/19	4/5/19	0.00	0.00	QC5		EL
190	SprayPaint	12 pcs	4/5/19	4/5/19	0.00	1.20	Spray Paint		OK 19-4-3 DAS 40
200	QC	12 pcs	4/5/19	4/5/19	0.00	0.00	QC3		APR 08 2019 40
210	Packaging	12 pcs	4/5/19	4/5/19	0.00	0.00	Packaging3-1	5+2603	APR 09 2019 40
220	QC21-SA	12 Ea	4/5/19	4/5/19	0.00	0.00	QC21		APR 11 2019 70

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 5147896

210 - Identify on inside surface using a permanent fine point marker with the following:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	39 sf (3.25 ea)	100-Waterjet - Flow - 1	5159673

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	39	274	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		
4	Wearplate	0.607inches ± 0.010	0.617 0.597		
5	Wearplate	2.940inches ± 0.030	2.970 2.910		
6	Wearplate	2.690inches ± 0.030	2.720 2.660		
7	Wearplate	3.527inches ± 0.010	3.537 3.517		
8	Wearplate	4.520inches ± 0.030	4.550 4.490		
9	Wearplate	5.063inches ± 0.010	5.073 5.053		
10	Wearplate	6.160inches ± 0.030	6.190 6.130		
11	Wearplate	0.600inches ± 0.030	0.630 0.570		
12	Wearplate	8.690inches ± 0.010	8.700 8.680		
13	Wearplate	30.790inches ± 0.010	30.800 30.780		
14	Wearplate	52.880inches ± 0.030	52.910 52.850		
15	Wearplate	62.770inches ± 0.010	62.780 62.760		
16	Wearplate	74.420inches ± 0.010	74.430 74.410		
17	Wearplate	75.520inches ± 0.030	75.550 75.490		
18	Wearplate	0.050inches ± 0.010	0.060 0.040		

Plex 3/19/19 8:58 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S167109



Part: D3319-3

Job No: 192190

Serial No/Batch: S167109

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/28/19